

Date: Thursday, 2/9/2006 1:49:46 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACER
Job Number : 25771	
Estimate Number : 11209	
P.O. Number : N/A	Part Number : D31701
This Issue : 2/9/2006 S.O. No. : N/A	Drawing Number : D3170 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 25113	Material : N/A
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 2/21/2006
Checked & Approved By : <u>KJ 06.02.10</u>	Qty: 10 Um: Each
Comment : Est Rev:A 02.10.11 New issue KJ	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S080	5052-H32 .080 Sheet
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Comment: Qty.: 0.0655 sf(s)/Unit Total: 0.6552 sf(s)
 Material: 5052-H32 (QQ-A-250/8) 0.080" thick
 (M5052H32S.080)
 Batch: M19729

JF 06/02/27 10

2.0	SHEAR	SHEAR
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Comment: SHEAR
 Cut blanks: 11.990" x 0.750" (-0.00/+0.010)

JF 06/02/27 10

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine per folio FA282 and Dwg D3170

JF 06/02/27 10

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JF 06/02/27 10

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SA 06.02.27 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 06/03/01

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

SAP 06/02/28

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAP 06/02/28

(10)

8.0

QC3/5

INSPECT WORK/WING WALK



Comment: INSPECT WORK/CHEMICAL CONVERSION

06-02-28

60

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PAT SUPPLY

PO 6/2/28 (10)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/03/01

Job Completion



W 06-03-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

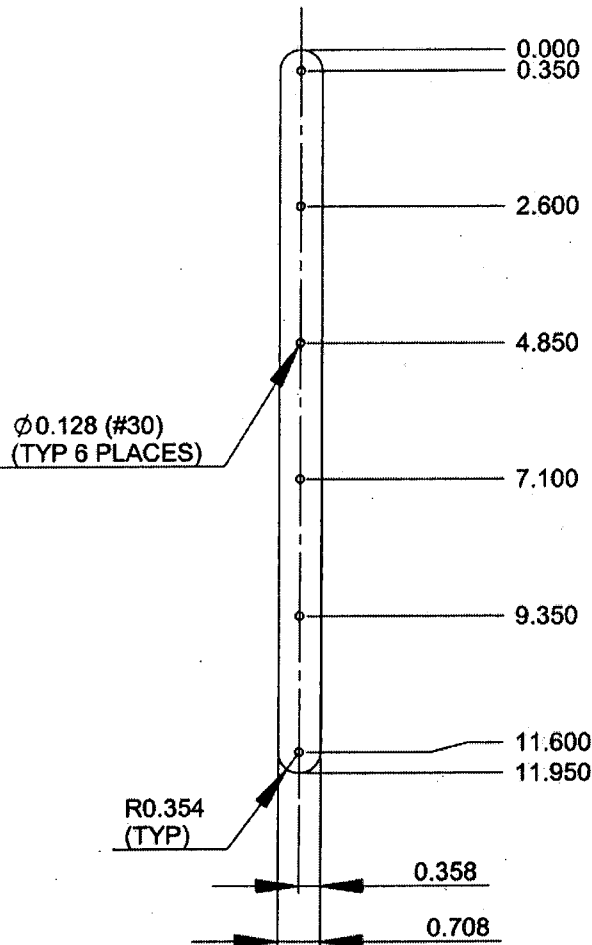
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3170	REV. A SHEET 1 OF 1
DATE 02.09.11		TITLE SPACER	SCALE 1:3
A	02.09.11	NEW ISSUE	

RELEASED
02.09.20 *[Signature]*



D3170-1 SPACER

- 1) MATERIAL: 5052-H32 (QQ-A-250/8) 0.080 THICK (REF DART SPEC. M5052H32S-080)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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